

Work Order ID 101376

101376

Page 1

Wednesday, May 08, 2013 1:54:31 PM

Item ID: D058-677-011

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Heli-Access-Step LH

Stop ***NS2***

Start Date: 5/8/2013 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 5/10/2013 Req'd Qty: 1.00 ***1***

Customer:

Reference: RETURN

Approvals: Process Plan: mf Date: 13-5-08

Tooling:

Date:

Run Start ***NR1***

QC: Date: SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2943	RevC								

270

0.00

270

QC

Quality Control

Memo

0.00

INSPECT RA 111511 D058-677-011 B#81610

PICK NEW HARWARE :

AN4-14A X 8

AN4-15A X 4

NAS1149D0463J X 12

MS21042L4 X 12

RETURN UNDER ORIGINAL BATCH NUMBER:

~~D2731-3 X 2 B#73417~~ W/45

D2731-7 X 2 B#78922

D3394-041 X 2 B#74505 W/45

D3394-043 X 2 B#80217

D2943-041 X 1 B#81610

D2732B030 X 8 B#83560

DART Dart Aerospace Ltd. 1270 ABERDEEN ST. HAWKESBURY ON CANADA K0A 1K7				QC APPROVAL #08-89 TEL: 1-613-632-5200	
PN	D206-628-011	Q#6	CHG003		
DESC.	Heli-Access-Step LH	STC	SH98-14		
LOT	B84805	STC	SA00500SE		
MODEL	Bel 206A/B	STC			
MADE IN CANADA					

DAS
16
9-89
17/01/16

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Cust Item ID:

Required Date: 5/10/2013 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
280		0.00							
280									
Packaging	Memo	0.00							
Packaging	PICK NEW HARWARE : AN4-14A X 8 AN4-15A X 4 NAS1149D0463J X 12 MS21042L4 X 12 RETURN UNDER ORIGINAL BATCH NUMBER: D2731-3 X 2 B#73417 <i>nlq</i> D2731-7 X 2 B#78922 D3394-041 X 2 B#74505 <i>nlq</i> D3394-043 X 2 B#80217 D2943-041 X 1 B#81610 D2732B030 X 8 B#83560 ID AND STOCK UNDER NEW BATCH NUMBER								
290									
290									
QC	QC4- 100% Inspect kits for completeness	0.00							
Quality Control	Memo	0.00							

061

13/5/17 *sl*

smB
13-5.17

Work Order ID 101376***101376***

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Item ID: D058-677-011

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Heli-Access-Step LH

Stop ***NS2***

Start Date: 5/8/2013 Start Qty: 1.00

1

Cust Item ID:

Required Date: 5/10/2013 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

300

QC21- Final Inspection - Work Order Release

0.00

300

A16002

13/5/21 *[Signature]*

QC

Memo

0.00

Quality Control

mf
13-5-21

Picklist Print

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Page 1

Work Order ID: 101376
Parent Item: D058-677-011
Parent Item Name: Heli-Access-Step LH

Start Date: 5/8/2013

Required Date: 5/10/2013

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:B01.04.11Combined with D2943-041EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2943-041 Step, OH58		Manufactured	No				Each	0.0000		-1		1 x 8/16/10	135-8 MP
D2734 Step End Plate		Manufactured	No			110	Each	66.0000	2	2			SP

Location	Loc Qty	Loc Code
WA003	66	
80682	6	
84563	0	
91761	8	
95395	22	
98392	20	

A ME 13-5-21

D2731-3 Mounting Lug		Manufactured	No			240	Each	74.0000	2	-2			SP
-------------------------	--	--------------	----	--	--	-----	------	---------	---	----	--	--	----

Location	Loc Qty	Loc Code
ST467	74	
73417	24	
85505	50	

D3394-043 Lug Assembly		Manufactured	No			240	Each	78.0000	2	-2		78921	SP
---------------------------	--	--------------	----	--	--	-----	------	---------	---	----	--	-------	----

Location	Loc Qty	Loc Code
ST007	4	
80217	4	
ST465	74	
82760	10	
89729	40	
98328	24	

*2 anti
en stock
13/5/10*

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:25%;">Skid-tube <input type="checkbox"/></td> <td style="width:25%;">Crosstube <input type="checkbox"/></td> <td style="width:25%;">Water Jet <input type="checkbox"/></td> <td style="width:25%;">Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data <input type="checkbox"/>									
Equip/Tooling <input type="checkbox"/>									
Operator <input type="checkbox"/>									
Material <input type="checkbox"/>									
Setup <input type="checkbox"/>									
Other <input type="checkbox"/>									
Process <input type="checkbox"/>									
Supplier <input type="checkbox"/>									
Training <input type="checkbox"/>									
Unapproved <input type="checkbox"/>									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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Picklist Print

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Work Order ID: 101376

Parent Item: D058-677-011

Parent Item Name: Heli-Access-Step LH

Start Date: 5/8/2013

Required Date: 5/10/2013

Start Qty: 1.00

Required Qty: 1.00

D2732-030

Rubber Cushion

Manufactured No

240 Each 111.0000 8 -8

83560 SL

Location	Loc Qty	Loc Code
FG	86	
83560	86	
ST415	25	
92772	2	
98629	23	

SKP

D3394-041

Lug Assembly

Manufactured No

240 Each 98.0000 2 -2

SL

Location	Loc Qty	Loc Code
ST465	98	
74505	4	
82149	34	
84146	60	

SKP

AN4-14A

Bolt

Purchased No

240 Each 726.0000 8 8

13/5/9 SD

Location	Loc Qty	Loc Code
FG	5	
122141	5	
ST007	16	
121349	16	
ST357	13	
115374	1	
123352	12	
ST514	92	
124215	92	
ST517	600	
124221	600	

SKP

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Shop Packet Print

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NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

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Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Equip/Tooling <input type="checkbox"/>									
Operator <input type="checkbox"/>									
Material <input type="checkbox"/>									
Setup <input type="checkbox"/>									
Other <input type="checkbox"/>									
Process <input type="checkbox"/>									
Supplier <input type="checkbox"/>									
Training <input type="checkbox"/>									
Unapproved <input type="checkbox"/>									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions
---	---	---

☐ Ovalized
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge

☐ Pressure/Forced
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

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Work Order ID: 101376
Parent Item: D058-677-011
Parent Item Name: Heli-Access-Step LH

Start Date: 5/8/2013 Required Date: 5/10/2013
Start Qty: 1.00 Required Qty: 1.00

D2731-7

Mounting Lug

Manufactured No

240 Each 110.0000

2

-2

78922

[Handwritten signature]

Shp

Location	Loc Qty	Loc Code
ST466	40	
97497	40	
ST467	70	
71860	4	
78922	4	
85477	50	
89726	12	

2 routes en stock *[Handwritten signature]*

AN4-15A

Bolt

Purchased No

240 Each 210.0000

4

4

sh

[Handwritten signature]

Shp

Location	Loc Qty	Loc Code
FP001	8	
122141	8	
GA	100	
120449	100	
ST357	1	
123900	1	
ST514	101	
119449	8	
123525	93	

AN960JD416

Washer

NAS1149D0463J

Purchased No

240 Each 0.0000

12

12

M124778

[Handwritten signature]

MS21042L4

Nut

Purchased No

240 Each 3,467.0000

12

12

13/5/9 SP

Shp

Location	Loc Qty	Loc Code
FP001	50	
122452	38	
8182	12	
st507	3000	
125535	3000	
ST518	417	
124231	417	

12

[Handwritten signature]

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RA111511

Received @ Dart April 12th, 2013
Inspected @ Dart April 16th, 2013

Customer: AEROMASTER AIRWAYS
Customer Contact: TAMARA SEPULVEDA
Shipped from: MIAMI FL, US

D-21609-43

Instructions for RA 111511

- All hard ware has been used and to be scraped
 - AN4-134 qty x 4 M121652
 - AN4-14A qty x4 M121349
 - AN4-15A qty x4 M122141
 - AN960JD416 qty x12 M121912
 - MS21042L4 qty x12 M121444
- Return the following parts to stock under original Batch #'s if possible
 - D2731-7 qty x4 B78922
 - D3394-043 qty x4 B78921
 - D2732-030 qty x8 B83560
- D2721-041 B84807 step is actually a D2943-041 (D058-677-011) B81610
 - Return step to stock under D2943-041 / D058-677-011
 - With a new BATCH# *original batch number.*

03394-041?

Time Estimate = 2 HOURS

Departments Required: Stores & QC

Pictures Attached = NO

QTY INSPECTED = x1 D2934-041

**THIS INSTRUCTION SHEET MUST
BE ATTACHED TO THE
RESTOCKING WORK ORDER AT
ALL TIMES!!!!**

SMD

4.0 PARTS LIST:

Qty -011	Qty -012	Qty -013	Qty -014	Part Number	Description
X				D058-677-011	HELI-ACCESS-STEP™, LH
	X			D058-677-012	HELI-ACCESS-STEP™, RH
		X		D058-677-013	HELI-ACCESS-STEP™, LH
			X	D058-677-014	HELI-ACCESS-STEP™, RH
1		1		D2943-041	STEP ASSEMBLY LH
	1		1	D2943-042	STEP ASSEMBLY RH
		2	2	D3394-045	MOUNTING LUG (REPLACES D2230-1)
		2	2	D2230-3	MOUNTING LUG
2	2			D3394-041	MOUNTING LUG (REPLACES D2731-1)
2	2			D2731-3	MOUNTING LUG
2	2	2	2	D3394-043	MOUNTING LUG (REPLACES D2731-5)
2	2	2	2	D2731-7	MOUNTING LUG
8	8	8	8	D2732-030	RUBBER CUSHION
8	8	4	4	AN4-14A	BOLT
4	4	4	4	AN4-15A	BOLT
		4	4	AN4-16A	BOLT
12	12	12	12	AN960JD416	WASHER
12	12	12	12	MS21042L4	NUT (OR MS21042-4)

5.0 WEIGHT AND BALANCE:

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D058-677-011/ -013 HELI-ACCESS-STEP™, LH	8.15 lb 3.70 Kg	- 36.5 in - 0.93 m	- 297.5 in-lb - 3.30 m-kG	100.44 in 2.55 m	818.6 in-lb 9.44 m-kG
D058-677-012/ -014 HELI-ACCESS-STEP™, RH	8.15 b 3.70 Kg	+36.5 in +0.93 m	+297.5 in-lb +3.30 m-kG	100.44 in 2.55 m	818.6 in-lb 9.44 m-kG

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Revision: C

Date: 09.01.20

5.1 D206-628-011/-012/-021/-022/-031/-032 REGULAR DART HELI-ACCESS- STEPS™ PARTS LIST

Qty -011	Qty -012	Qty -021	Qty -022	Qty -031	Qty -032	Part Number	Description
X						D206-628-011	206 A/B STEP INSTALLATION LH
	X					D206-628-012	206 A/B STEP INSTALLATION RH
		X				D206-628-021	206 L/L1/L3/L4 STEP INSTALLATION LH
			X			D206-628-022	206 L/L1/L3/L4 STEP INSTALLATION RH
				X		D206-628-031	407 STEP INSTALLATION LH
					X	D206-628-032	407 STEP INSTALLATION RH
1						D2721-041	STEP ASSEMBLY LH
	1					D2721-042	STEP ASSEMBLY RH
		1		1		D2724-041	STEP ASSEMBLY LH
			1		1	D2724-042	STEP ASSEMBLY RH
				4	4	D2731-3	MOUNTING LUG
4	4	4	4			D2731-7	MOUNTING LUG
8	8	8	8	8	8	D2732-030	RUBBER CUSHION
				4	4	D3394-041	MOUNTING LUG
				4	4	*D3394-1	*MOUNTING LUG
				8	8	*MS35489-93	*GROMMET
4	4	4	4			D3394-043	MOUNTING LUG
4	4	4	4			*D3394-3	*MOUNTING LUG
8	8	8	8			*MS35489-93	*GROMMET
4	4			4	4	AN4-13A	BOLT
4	4	4	4	4	4	AN4-14A	BOLT
4	4	8	8	4	4	AN4-15A	BOLT
12	12	12	12	12	12	NAS1149D0463J	WASHER (AN960JD416)
12	12	12	12	12	12	MS21042L4	NUT (OR MS21042-4)

*DENOTES THAT PART IS INCLUDED IN ASSEMBLY ABOVE